



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

FEB 16 2018

D206-559-011
Job Sheet 172379



Part No: D206-559-011

Job Qty: 2 ea

Part Name: 206A/B Bearpaws



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 3/15/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG IIN-D206-559 REV L, DSI 9527 REV A IPP Rev:C 04.02.17 Blank size changed KJ/JLM IPP Rev:D 07-01-02 Was K10007 JLM IPP Rev:E 08-05-05 up a chg DD verified by:EC IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Stores/Pkg-2		FEB 20 2018
160	Packaging	2 pcs	3/15/18	3/15/18	0.00	0.00	Packaging1-2		FEB 20 2018
170	QC	2 pcs	3/15/18	3/15/18	0.00	0.00	QC4		
175	DC	2 pcs	3/15/18	3/15/18	0.00	0.00	DC		
180	Packaging	2 pcs	3/15/18	3/15/18	0.00	0.00	Packaging3-1		
190	QC21-FG	2 Ea	3/15/18	3/15/18	0.00	0.00	QC21		FEB 21 2018

Part Op 175 - Photocopy bluefile and create labels per PPPD206-559-011 CHG007
Descriptions: 180 - Identify and pack for shipping as per PPPD206-559-011

F9014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-17A	Bolt	16 Ea (8 ea)	90-Start up Operation	
AN4-20A	Bolt	16 Ea (8 ea)	90-Start up Operation	
D2182B050	Clamp Cushion Black 5.0 " Long	8 Ea (4 ea)	90-Start up Operation	
D2274	Radius Block	16 Ea (8 ea)	90-Start up Operation	
D2435	Bearpaw	4 Ea (2 ea)	90-Start up Operation	
D2438	Clamp	8 Ea (4 ea)	90-Start up Operation	
D2529	Washer	16 Ea (8 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	
NAS1149D0463J	Washer	32 Ea (16 ea)	90-Start up Operation	
QS200-M44S	Clamp	4 Ea (2 ea)	90-Start up Operation	



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Container No: S043765



Part: D206-559-011

Job No: 172379

Serial No/Batch: S043765

Revision: IIN-D206-559, DSI 9527

Inspector:

Date: 02/20/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-17A	16	699	0
	AN4-20A	16	392	0
	D2182B050	8	60	0
	D2274	16	105	0
	D2435	4	6	0
	D2438	8	73	0
	D2529	16	3,046	0
	MS21042L4	16	1,443	0
	NAS1149D0463J	32	2,845	0
	QS200-M44S	4	18	0

Part Specifications

Specifications could not be found.

 **Kim Johnston**

From: Sonia Quirion
Sent: Tuesday, February 20, 2018 6:34 AM
To: Kim Johnston
Subject: p/w

d350-607-511 x6

d206-559-011 x2

PAGE 1 OF 1

Description: BEARPAW INSTALLATION (206/407)[illegible]

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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Master Unit 001025

Containers on Master Unit 001025				
Serial No	Part No	Customer Part No	Status	Quantity
S043761	AN4-17A	AN4-17A	Allocated	0
S043758	AN4-20A	AN4-20A	Allocated	0
S043755	D2182B050	D2182B050	Allocated	0
S043754	D2274	D2274	Allocated	16
S043736	D2435	D2435	Allocated	0
S043732	D2438	D2438	Allocated	0
S043731	D2529	D2529	Allocated	16
S043726	MS21042L4	MS21042L4	Allocated	16
S014733	NAS1149D0463J	NAS1149D0463J	Allocated	27
S043720	NAS1149D0463J	NAS1149D0463J	Allocated	5
S043719	QS200-M44S		Allocated	0

8 16X
8 16X
8 16X
8 16X
2 4X
4 8X
8 16X
8 16X
16 32X
2 4X

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP